

Work Order ID 62198

Wednesday, September 22, 2010 10:22:38 A

Page 1

Item ID: D4155-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Bar

Start Date: 9/22/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 9/29/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan: PLDate: 10-9-22

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4155

A

100

0.00



Waterjet

FLOW CNC Waterjet

Memo

0.00

1-Cut as per Dwg

Dwg Rev: AProg Rev: A

2-Deburr if necessary

10-9-27

(4)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

10-9-27

pb →

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D4155-1 PAR #: _____ Fault Category: Small Fab /w-Int. NCR: Yes No DQA: / Date: 10/10/01
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: / Date: 10/10/01

NCR: <u>62198</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>10/9/77</u>	<u>#100</u>	<u>Found at inspection qty of</u> <u>w/it dim is .030 measures</u> <u>from .030 to .040 on one side</u> <u>R.L. Press. (Tapered cut.)</u> <u>on a thick part</u>	<u>/</u> <u>OS/ur</u>	<u>→ Scrap + Destroy Qty of</u> <u>no replace.</u> <u>Welder cannot use too</u> <u>thin</u>	<u>10/9/77</u>	<u>S</u> <u>10/10/77</u>	<u>/</u> <u>OS/ur</u>	<u>S</u> <u>10/10/77</u>
				<u>(welder cannot use too thin)</u>				

NOTE: Date & initial all entries

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Start Date: 9/22/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 9/29/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

Solarizing

(X3)

130

Weld per dwg A/R Hardcoat steel Batch: _____

0.00



Large Fab

Memo

0.00

Large Fab

M115553

EL 10-9-28 (X3)

140

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

D 10.09.29.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 3

Item ID: D4155-1

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Setup Start



Revision ID:

Item Name: Bar

Stop



Start Date: 9/22/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 9/29/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150



QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

③D 10.09.30

160



Identify as per dwg & Stock Location: w/o

0.00

Packaging

Memo

0.00

Packaging

B 6296

EZ 10-9-29

170



QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/09/30

mf
10-9-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, September 22, 2010 10:22:42 AM

Page 1

Work Order ID: 62198

Parent Item: D4155-1

Parent Item Name: Bar




Start Date: 9/22/2010

Required Date: 9/29/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 10.08.03 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B0.500X012.000  304 BAR .500 X 12.00		Purchased	No			100	sf	2.9410	1.27	5.347368			



IB 10-9-27

m 304B0.500X2.500

Location

MAT53

112778

112697

Loc Qty

2.941

2.941

Loc Code

112697

④.

W/O:		WORK ORDER CHANGES					
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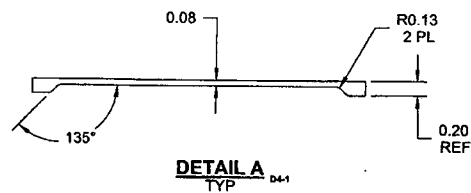
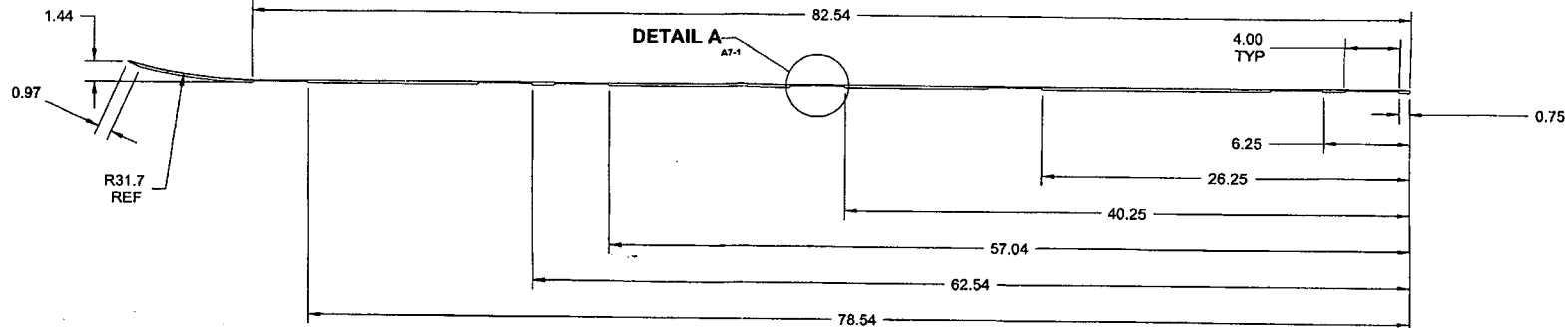
8 7 6 5 4 3 2 1

D

C

B

A



D4155-1 BAR

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER





NO. *42198*

BA 10-9-22

RELEASED
2010-09-15
MM

NOTES:

- 1) MATERIAL : AISI 304/316 STAINLESS STEEL BAR, 0.50 THICK PER ASTM A276 (REF. DART SPEC. M304B)
- 2) FINISH : NONE
- 3) TOLERANCES : PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS : INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES : 0.005 TO 0.010 MAX
- 6) IDENTIFICATION : NONE
- 7) WEIGHT : 2.16 lbs

A		NEW ISSUE		SC		10.07.22	
REV.		DESCRIPTION				BY DATE	
DESIGN		SC		DART AEROSPACE USA, INC. PORT HADLOCK, WA			
DRAWN		SC					
CHECKED				DRAWING NO.		REV.	
MFG. APPR.				D4155		SHEET 1 OF 1	
APPROVED				TITLE		SCALE	
DE APPR.				BAR		NT	
DATE		10.07.22		COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS UNCLASSIFIED AND IS SUPPLIED ON THE UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMBINED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.			

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